

Work Order ID 83994

83994

Page 1

May-01-12 10:35:32 AM

Item ID: D2332-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lid Prop Assembly 6.69" long

Start Date: 01/05/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: ALJ

Date: 12/05/01

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2332	Rev C1								

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

10

FF 12-05-20

110

0.00

110

Brake NC

Memo

0.00

Brake NC

Punch and form D2332-11 to length as per dwg D2332 using DT8012
(need 2 per ass'y)

10

FF 12-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00

120

Small Fab

Memo

0.00

10

FB 12-05-29

Small Fab

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459
(drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

10

WH 12-05-29

Quality Control

140

0.00

140

Large Fab

Memo

0.00

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
*****ensure nothing is inside of tube before welding*****

S.S Rod batch: M17/607

> 20/CE 12-6-4

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Required Date: 15/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

0.00

170

Small Fab

Memo

0.00

Small Fab

1- Tumble

2- Assemble as per dwg D2332

PC 12.06.04

10X

Sizelover

(40)

B12-6-4

(10)

FF 12-06-06

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

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Date:

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Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location: SS/2 0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release 0.00

200

QC

Memo

0.00

Quality Control

SS

10

SS 12/06/06

12/6/8

200-7

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

May-01-12 10:35:36 AM

Page 1

Work Order ID: 83994

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Parent Item: D2332-041

D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B02.08.12Re-format; Incorporated D2332-13/-11/-7/-5KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304R.250		Purchased	No			100	f	14.5500	0.1	1.052632			
-----------	--	-----------	----	--	--	-----	---	---------	-----	----------	--	--	--

M304R 250

304 SS Round bar .250

**

(10)

FF 12-05-29

Location

Loc Qty

Loc Code

MAT028

14.55

114482

2.55

120243

12

1.052632

M304TR1.000W.049

Purchased

No

100

f

60.0000

0.43

4.526316

M304TR1 000W 049

304 RD Tube 1.00 x .049W

**

FF 12-05-29

Location

Loc Qty

Loc Code

MAT018

60.000015

117598

0.000015

120654

60

4.526316

M304TR0.500W.035

Purchased

No

110

f

172.5474

1.25

13.15789

M304TR0 500W 035

304 RD Tube .500 x .035W

**

FF 12-05-29

Location

Loc Qty

Loc Code

MAT017

172.5473823

115535

0.913

116720

1.66068

117598

7.6415923

119160

4.79

119644

2.1209

120633

155.42121

13.15789

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Parent Item: D2332-041

D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 10.00

Required Qty: 10.00

AN4-4A Purchased No

170 Each 83.0000 1 10

AN4-4A

Bolt

**

(10) FF 12-06-06

Location

Loc Qty

Loc Code

FP001

6

114615

6

ST355

77

120187

31

121285

46

10

AN960JD416L NAS1149D0416J Purchased No

170 Each 8.0000 3 30

*AN960JD416I *

Washer

**

(10) FF 12-06-06

Location

Loc Qty

Loc Code

FP002

8

110153

8

30

MS21042L4

Purchased No

170 Each 5,520.000 1 10

MS21042I 4

Nut

**

(10) FF 12-06-06

Location

Loc Qty

Loc Code

ST300

5520

119075

520

121011

2000

121444

3000

10

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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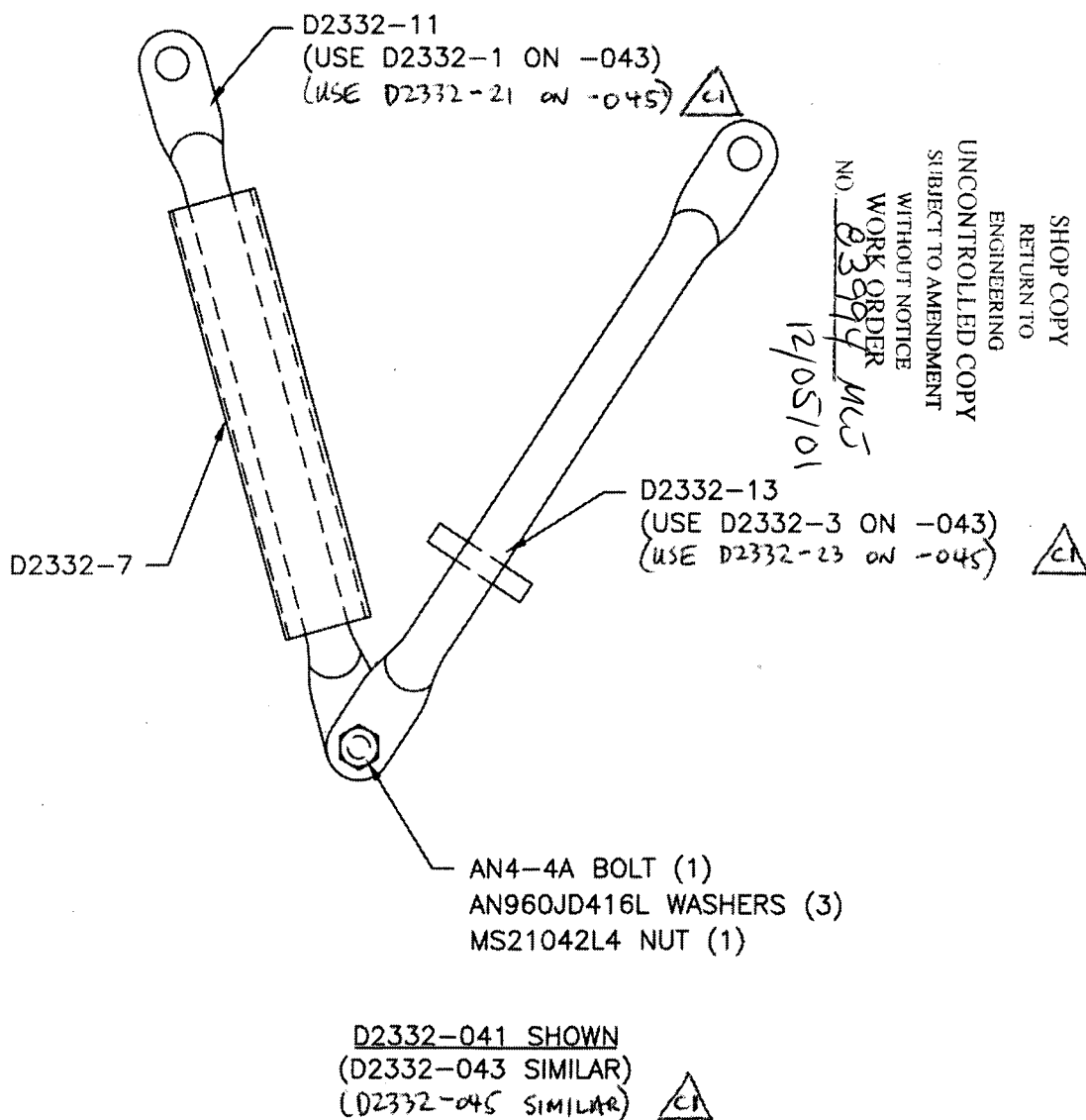
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NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04



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Dart Aerospace Ltd

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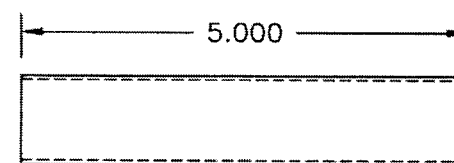
NOTE: Date & initial all entries

DART

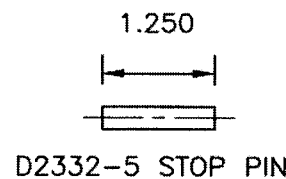


DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 03.07.03	TITLE LID PROP ASSEMBLY	REV. C
	D2332	SHEET 2 OF 2
		SCALE 1:2
C	03.07.03	MAKE -041 PROP 6.69" LONG (END)
C1	03.08.06	MAKE -043 PROP 8.00" LONG (END)
		ADD -045 PROP 7.25" LONG

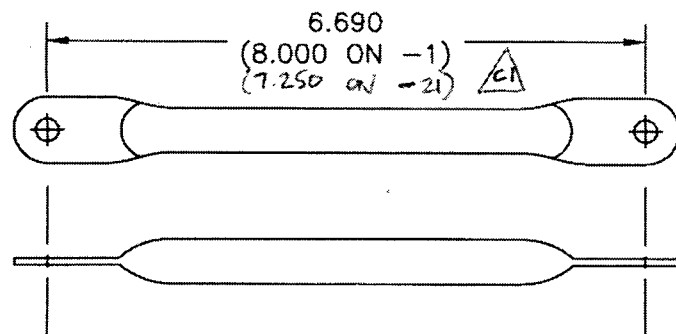
83994



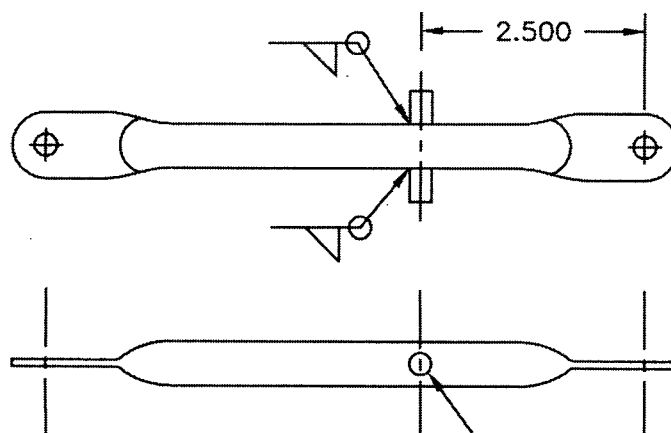
D2332-7 LOCKING COLLAR



D2332-5 STOP PIN



D2332-11 PROP
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)



NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04

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